

**Work Order ID 67230**

Friday, March 11, 2011 3:39:57 PM



Page 1

Item ID: D4150-3

Accept



Setup Start



Revision ID:

Item Name: Arm Plate

Stop



Start Date: 3/14/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: *mk*

Date: 11-03-1

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4150

B

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D4150

Prog Rev: *B*Dwg Rev: *B*

Deburr as required

0.00

*mk* 11 03 15 (12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

*mk* 11 03 15 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67230**

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Item ID: D4150-3

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/15

(42)

150

Identify as per dwg &amp; Stock Location: 133

0.00



Packaging

Memo

0.00

Packaging

11/3/15 (12x) SP

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/15

C21103/15

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, March 11, 2011 3:39:53 PM

Page 1

Work Order ID: 67230



Parent Item: D4150-3



Parent Item Name: Arm Plate

Start Date: 3/14/2011

Required Date: 3/16/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

37.5000

0.0254

0.320842



304/316 0.125 Sheet

m/ 11-03-15

Location

Loc Qty

Loc Code

MAT

37.5

116623

37.5

0.320842

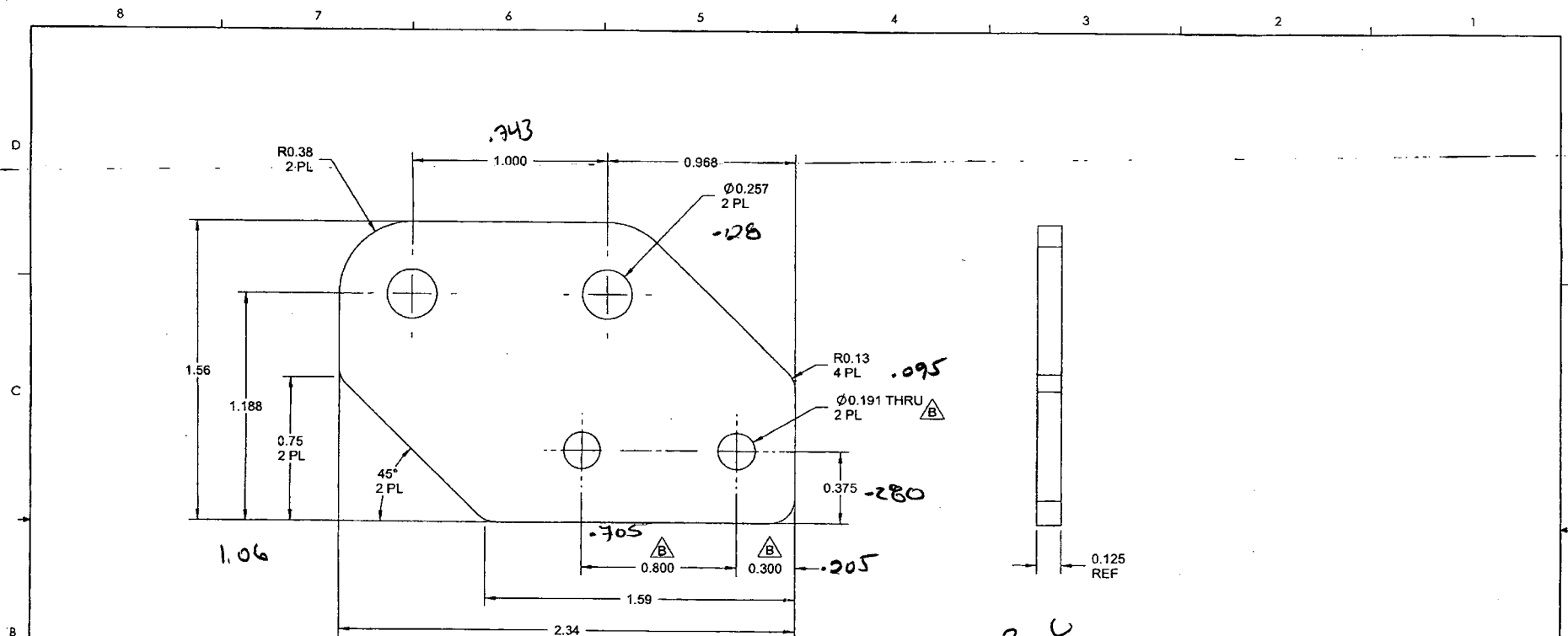
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**D4150-3 ARM PLATE**

**RELEASED**  
2010-07-16

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 28 FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
DATE	10.07.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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**NOTE:** Date & initial all entries



09

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 67230
<b>Description:</b> Arm Plate		<b>Part Number:</b> D4150-3
<b>Inspection Dwg:</b> D4150	<b>Rev:</b> B	<b>Page 1 of 1</b>

**FIRST ARTICLE INSPECTION CHECKLIST**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	0.192	✓		VERN	MM-01
Ø0.257	+0.006/-0.001	0.257	✓		VERN	"
1.000	+/-0.010	1.007	✓		VERN	"
0.968	+/-0.010	0.970	✓		H-G	31006
0.375	+/-0.010	0.378	✓		VERN	MM-01
0.300	+/-0.010	0.302	✓		VERN	"
0.800	+/-0.010	0.803	✓		VERN	"
1.59	+/-0.030	1.59	✓		VERN	"
2.34	+/-0.030	2.342	✓		VERN	"
0.75	+/-0.030	0.75	✓		VERN	"
1.56	+/-0.030	1.569	✓		VERN	"
1.188	+/-0.010	1.187	✓		H-G	31006
0.125	+/-0.010	0.116	✓		VERN	MM-01
<div>Task # 31006</div>						

<b>Measured by:</b> [Signature]	<b>Audited by:</b> S	<b>Preliminary Approval:</b>	N/A
<b>Date:</b> 11-03-15	<b>Date:</b> 11/03/15	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	[Signature]

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